

# Work Order ID 137729

Tuesday, October 27, 2015 8:48:04 AM

**\*137729\***

Page 1

Item ID: D3259-1 Accept **\*N900040100\*** Setup Start **\*NS1\***  
Revision ID: Stop **\*NS2\***  
Item Name: Panel  
Start Date: 10/7/2015 Start Qty: 4.00 **\*4\*** Cust Item ID:  
Required Date: 10/7/2015 Req'd Qty: 4.00 **\*4\*** Customer:  
Reference:

Approvals: Process Plan: ML5 Date: **OCT 27 2015** Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |
|----------|--------------|
| D3259    | Rev B        |

|                   |                                         |      |  |  |  |  |  |  |  |
|-------------------|-----------------------------------------|------|--|--|--|--|--|--|--|
| 100               | FLOW WATER JET                          | 0.00 |  |  |  |  |  |  |  |
| <b>*100*</b>      |                                         |      |  |  |  |  |  |  |  |
| Waterjet          | Memo                                    | 0.01 |  |  |  |  |  |  |  |
| FLOW CNC Waterjet | 1-Cut as per Dwg D3259                  |      |  |  |  |  |  |  |  |
|                   | Dwg Rev: <u>B</u>                       |      |  |  |  |  |  |  |  |
|                   | Prog Rev: <u>B</u>                      |      |  |  |  |  |  |  |  |
|                   | 2-Deburr if necessary                   |      |  |  |  |  |  |  |  |
| 110               | QC2- Inspect parts off machine FAI/FAIB | 0.00 |  |  |  |  |  |  |  |
| <b>*110*</b>      |                                         |      |  |  |  |  |  |  |  |
| QC                | Memo                                    | 0.00 |  |  |  |  |  |  |  |
| Quality Control   |                                         |      |  |  |  |  |  |  |  |

*Rush*

(4) \_\_\_\_\_ 02/15/10/28

(4) \_\_\_\_\_ 02/15/10/28



**Work Order ID 137729**

Tuesday, October 27, 2015 8:48:04 AM

**\*137729\***

Page 3

Item ID: D3259-1 Accept **\*N900040100\*** Setup Start **\*NS1\***  
Revision ID: Stop **\*NS2\***  
Item Name: Panel  
Start Date: 10/7/2015 Start Qty: 4.00 **\*4\*** Cust Item ID:  
Required Date: 10/7/2015 Req'd Qty: 4.00 **\*4\*** Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

| Sequence ID/<br>Work Center ID | Operation<br>Description                    | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|---------------------------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 150                            | Identify as per dwg & Stock Location: _____ | 0.00                 |         |        |              |               |               |                  |                |
| <b>*150*</b>                   |                                             |                      |         |        |              |               |               |                  |                |
| Packaging                      | Memo                                        | 0.00                 |         |        |              | 4             | FF            |                  | OCT 28 2015    |
| Packaging                      | LOCATION : GA                               |                      |         |        |              |               |               |                  |                |
| 160                            | QC21- Final Inspection - Work Order Release | 0.00                 |         |        |              |               |               |                  |                |
| <b>*160*</b>                   |                                             |                      |         |        |              |               |               |                  |                |
| QC                             | Memo                                        | 0.01                 |         |        |              |               |               |                  |                |
| Quality Control                |                                             |                      |         |        |              |               |               |                  |                |

SA 151029

# Picklist Print

Tuesday, October 27, 2015 8:48:07 AM

Page 1

Work Order ID: 137729

**\*137729\***

Parent Item: D3259-1

**\*D3259-1\***

Parent Item Name: Panel

Start Date: 10/7/2015

Required Date: 10/7/2015

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 07-07-19 JLM Verified By:EC IPP REV  
B:AS PER REV B 10-05-19 JLM VERIFIED BY:EC

| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Qty per Kit | Total<br>Qty | Qty<br>Issued | Date<br>Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| M2024T3S.032                    |                        | Purchased     |             | No                  |                  | 100             | sf                 | 181.5000       | 1.388       | 5.844210     |               |                |        |

**\*M2024T3S 032\***

2024-T3 .032 sheet

**\*\***

*02/15/10/28*

Location

Loc Qty

Loc Code

MAT022

181.5

M130497

8.5

M132875

77

M133452

96

5

|                              |               |                             |
|------------------------------|---------------|-----------------------------|
| <b>DART AEROSPACE LTD</b>    |               | <b>Work Order:</b> 137729   |
| <b>Description:</b> Panel    |               | <b>Part Number:</b> D3259-1 |
| <b>Inspection Dwg:</b> D3259 | <b>Rev:</b> B | <b>Page 1 of 1</b>          |

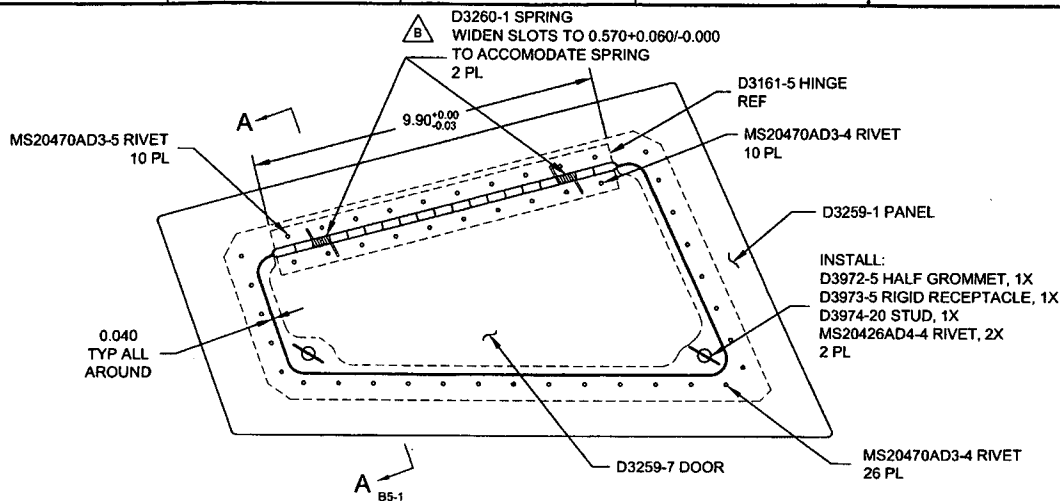
### FIRST ARTICLE INSPECTION CHECKLIST

| Drawing Dimension | Tolerance     | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|---------------|------------------|--------|--------|----------------------|----------|
| 15.188            | +/-0.010      | 15.184           | /      |        | Viper-02             |          |
| 1.000             | +/-0.005      | 1.001            | /      |        | Tap                  |          |
| 9.000             | +/-0.005      | 9.002            | /      |        | Viper-01             |          |
| R0.50             | +/-0.030      | .50              | /      |        |                      |          |
| 0.875             | +/-0.005      | .874             | /      |        |                      |          |
| 5.000             | +/-0.005      | 4.999            | /      |        |                      |          |
| R0.13             | +/-0.030      | .13              | /      |        |                      |          |
| 17.125            | +/-0.010      | 17.125           | /      |        |                      |          |
| 12.000            | +/-0.005      | 12.006           | /      |        |                      |          |
| 3.500             | +/-0.005      | 3.499            | /      |        |                      |          |
| 0.875             | +/-0.005      | .876             | /      |        |                      |          |
| 1.745             | +/-0.010      | 1.749            | /      |        |                      |          |
| 0.260             | +/-0.010      | .264             | /      |        |                      |          |
| 2.150             | +/-0.010      | 2.145            | /      |        |                      |          |
| 1.800             | +/-0.010      | 1.806            | /      |        |                      |          |
| 0.250             | +/-0.010      | .255             | /      |        |                      |          |
| 1.750             | +/-0.010      | 1.756            | /      |        |                      |          |
| Ø0.098            | +0.005/-0.000 | Ø.098            | /      |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |

|                        |                                      |                              |
|------------------------|--------------------------------------|------------------------------|
| <b>Measured by:</b> DK | <b>Audited by:</b> DAS<br>S3<br>9-89 | <b>Preliminary Approval:</b> |
| <b>Date:</b> 15/10/28  | <b>Date:</b> OCT 28                  | <b>Date:</b>                 |

| Rev | Date     | Change                     | Revised by | Approved |
|-----|----------|----------------------------|------------|----------|
| A   | 04.08.25 | New Issue P/O D412-705-019 | KJ/JLM     |          |
| B   | 10.06.07 | Dwg Rev updated            | KJ         |          |

8 7 6 5 4 3 2 1

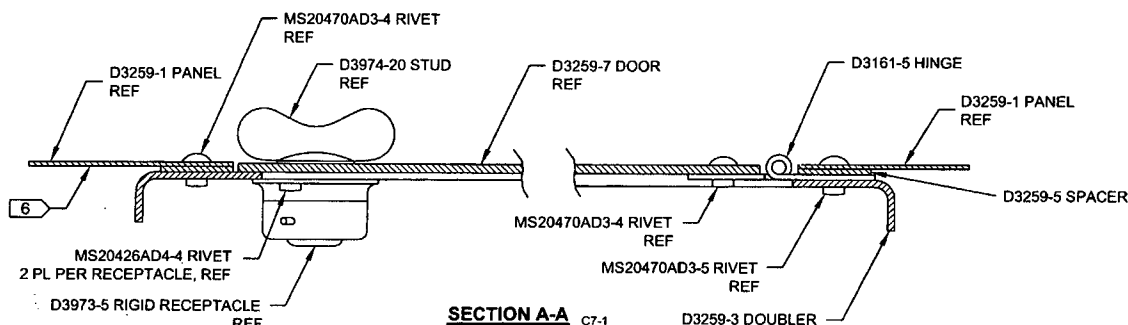


| ITEM | QTY | PART NUMBER  | DESCRIPTION                |
|------|-----|--------------|----------------------------|
| 1    | X   | D3259-041    | ACCESS PANEL ASSEMBLY      |
| 2    | 1   | D3161-5      | HINGE                      |
| 3    | 1   | D3259-1      | PANEL                      |
| 4    | 1   | D3259-3      | DOUBLER                    |
| 5    | 1   | D3259-5      | SPACER                     |
| 6    | 1   | D3259-7      | DOOR                       |
| 7    | 2   | D3260-1      | SPRING                     |
| 8    | 2   | D3972-5      | GROMMET, HALF, DZUS        |
| 9    | 2   | D3973-5      | RECEPTACLE, RIGID, DZUS    |
| 10   | 2   | D3974-20     | STUD, WING HEAD, 5/16 DZUS |
| 11   | 36  | MS20470AD3-4 | RIVET                      |
| 12   | 10  | MS20470AD3-5 | RIVET                      |
| 13   | 4   | MS20426AD4-4 | RIVET                      |

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137729 ML5  
15-10-08

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2009-10-08



**SECTION A-A**  
VIEW ROTATED  
NOT TO SCALE

**D3259-041 ACCESS PANEL ASSEMBLY**

- NOTES:**
- 1) MATERIAL: N/A
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: NONE
  - 6) IDENTIFICATION: IDENTIFY WITH P/N "D3259-041" AND B/N "BXXXXX" USING FINE POINT PERMANENT MARKER
  - 7) WEIGHT: 1.2 lbs

|            |                                                   |    |          |
|------------|---------------------------------------------------|----|----------|
| B          | REFORMAT DWG, R0.25 WAS R0.18 (ZN B8-4, B1-5)     | CP | 09.08.12 |
| A          | -3F REDESIGN (SHT 8), WIDEN SLOTS (ZN D6-1, D5-2) | CP | 04.02.25 |
| REV.       | DESCRIPTION                                       | BY | DATE     |
| DESIGN     | RF                                                |    |          |
| DRAWN      |                                                   |    |          |
| CHECKED    |                                                   |    |          |
| MFG. APPR. |                                                   |    |          |
| APPROVED   |                                                   |    |          |
| DE APPR.   |                                                   |    |          |
| DATE       | 09.08.12                                          |    |          |

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

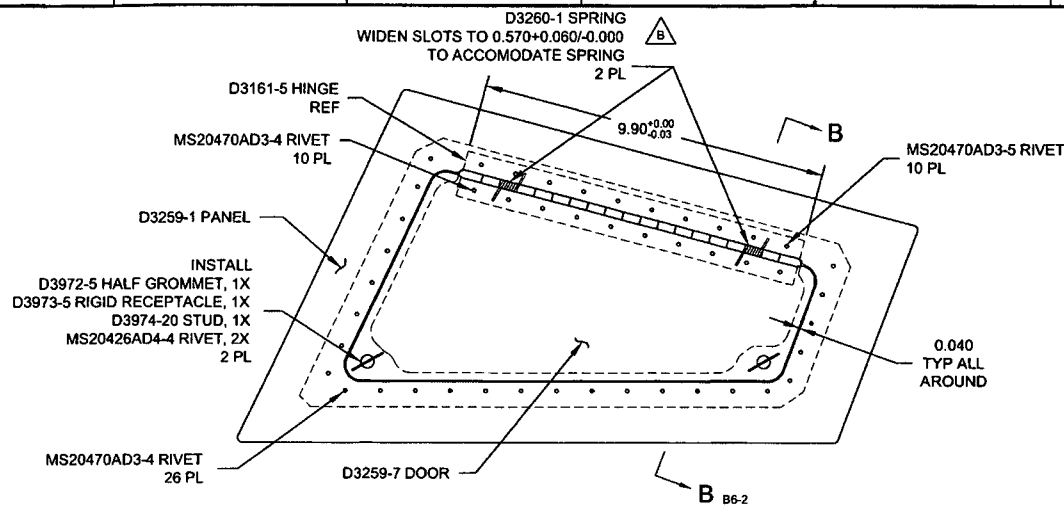
DRAWING NO. D3259  
REV. B  
SHEET 1 OF 8

TITLE  
ACCESS PANEL ASSEMBLY  
SCALE  
NTS

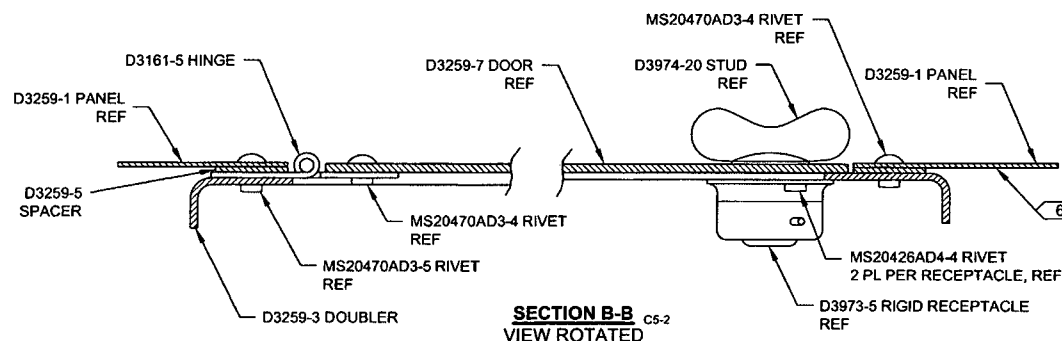
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8 7 6 5 4 3 2 1

8 7 6 5 4 3 2 1



| ITEM | QTY | PART NUMBER  | DESCRIPTION                |
|------|-----|--------------|----------------------------|
| 1    | X   | D3259-042    | ACCESS PANEL ASSEMBLY      |
| 2    | 1   | D3161-5      | HINGE                      |
| 3    | 1   | D3259-1      | PANEL                      |
| 4    | 1   | D3259-4      | DOUBLER                    |
| 5    | 1   | D3259-5      | SPACER                     |
| 6    | 1   | D3259-7      | DOOR                       |
| 7    | 2   | D3260-1      | SPRING                     |
| 8    | 2   | D3972-5      | GROMMET, HALF              |
| 9    | 2   | D3973-5      | RECEPTACLE, RIGID, DZUS    |
| 10   | 2   | D3974-20     | STUD, WING HEAD, 5/16 DZUS |
| 11   | 36  | MS20470AD3-4 | RIVET                      |
| 12   | 10  | MS20470AD3-5 | RIVET                      |
| 13   | 4   | MS20426AD4-4 | RIVET                      |



# **D3259-042 ACCESS PANEL ASSEMBLY**

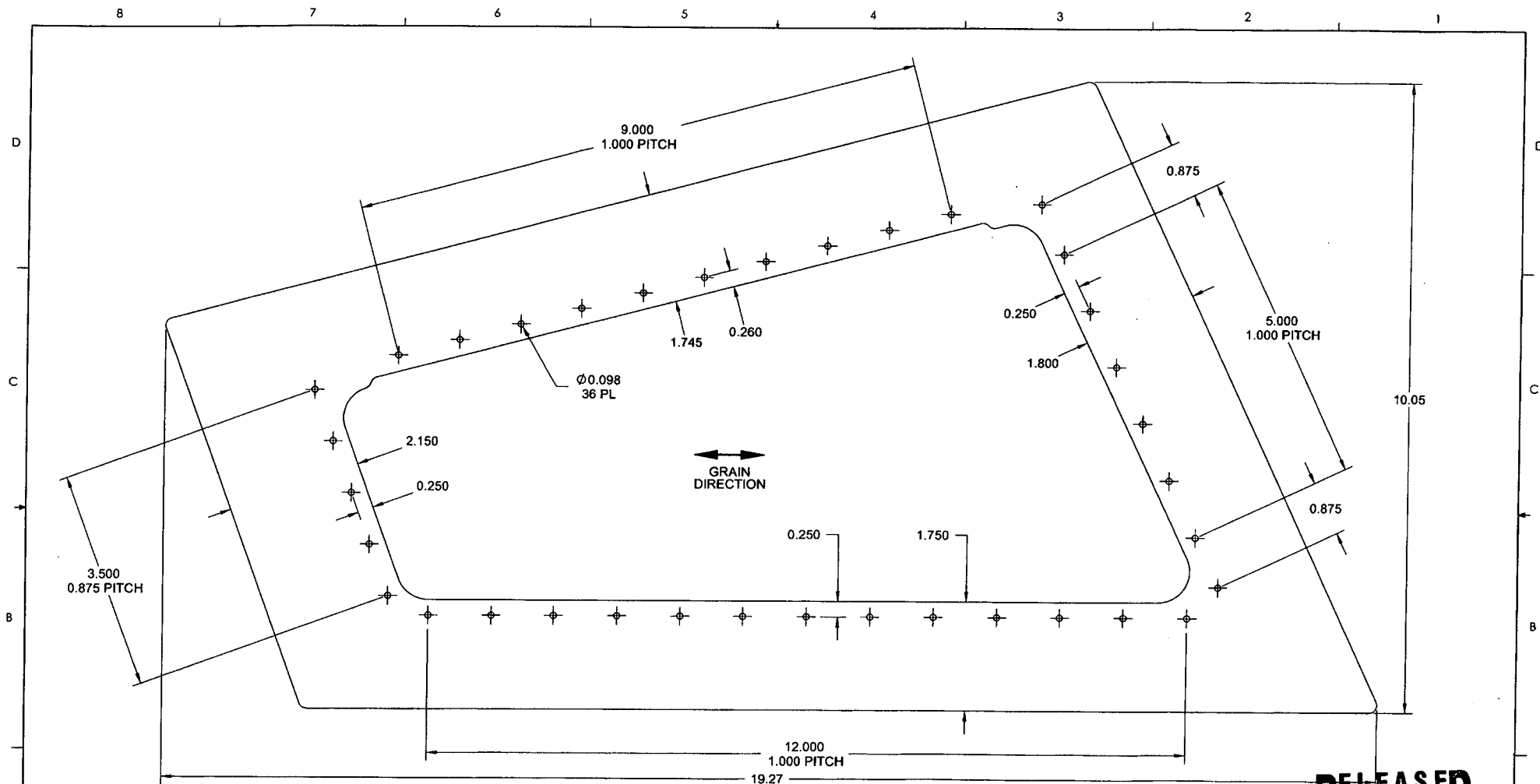
## **NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: IDENTIFY WITH P/N "D3259-042" AND B/N "BXXXXX" USING FINE POINT PERMANENT MARKER
- 7) WEIGHT: 1.2 lbs

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|            |          |                                                                                                                                                                                                                                                                  |
|------------|----------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| DESIGN     | RF       | <b>DART AEROSPACE LTD</b>                                                                                                                                                                                                                                        |
| DRAWN      |          | HAWKESBURY, ONTARIO, CANADA                                                                                                                                                                                                                                      |
| CHECKED    |          | DRAWING NO. REV. B                                                                                                                                                                                                                                               |
| MFG. APPR. |          | D3259 SHEET 2 OF 8                                                                                                                                                                                                                                               |
| APPROVED   |          | TITLE SCALE                                                                                                                                                                                                                                                      |
| DE APPR.   |          | ACCESS PANEL ASSEMBLY NTS                                                                                                                                                                                                                                        |
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8 7 6 5 4 3 2 1



**D3259-1 PANEL**

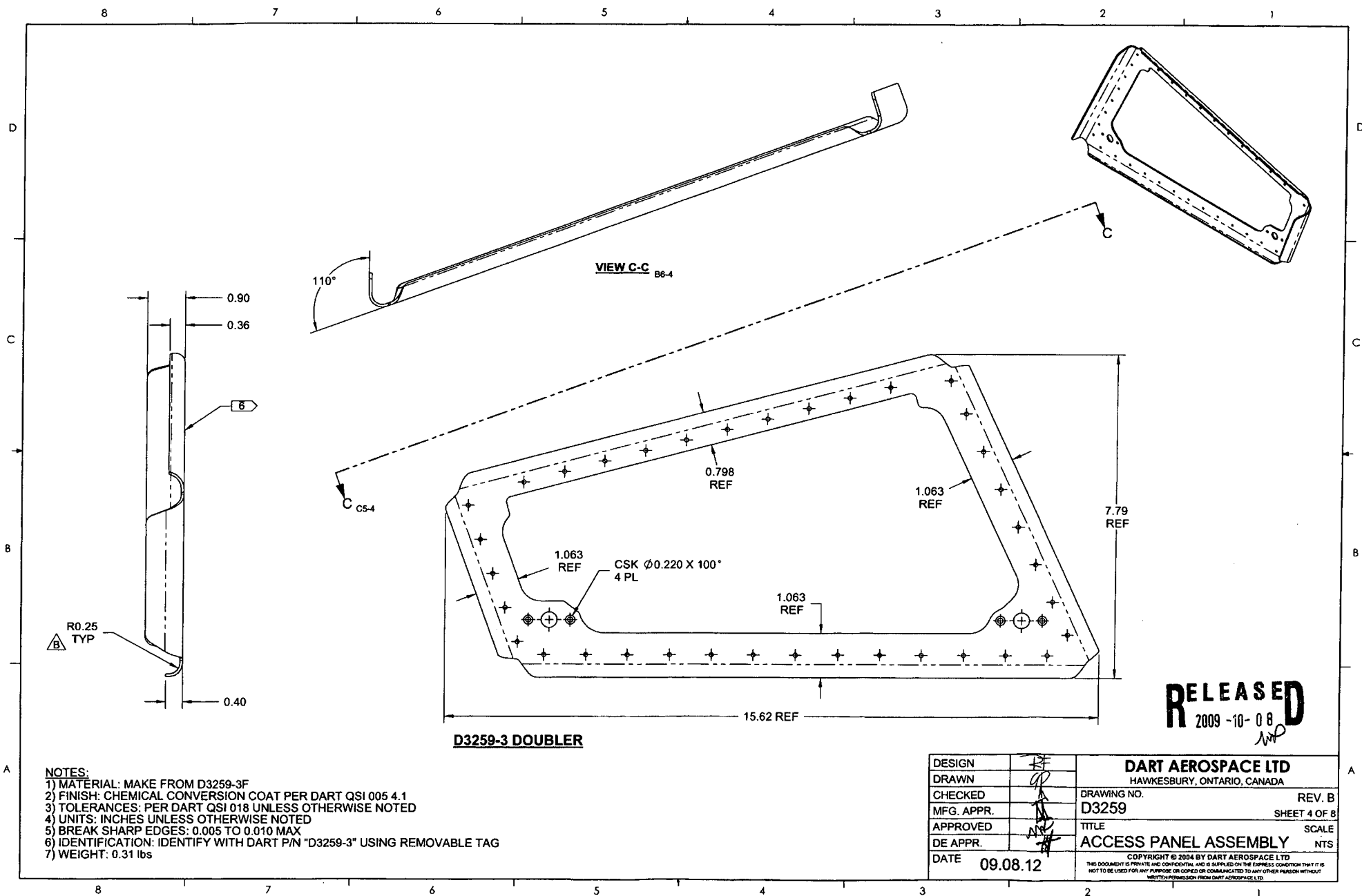
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2009-10-08

**NOTES:**

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.032 THICK PER AMS-QQ-A-250/4 OR AMS 4037 OR ASTM B209 REF DART SPEC. M2024T3S.032
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3259-1" USING REMOVABLE TAG
- 7) WEIGHT: 0.25 lbs
- 8) MAKE PER DWG FILE "D3259-1B.DXF"

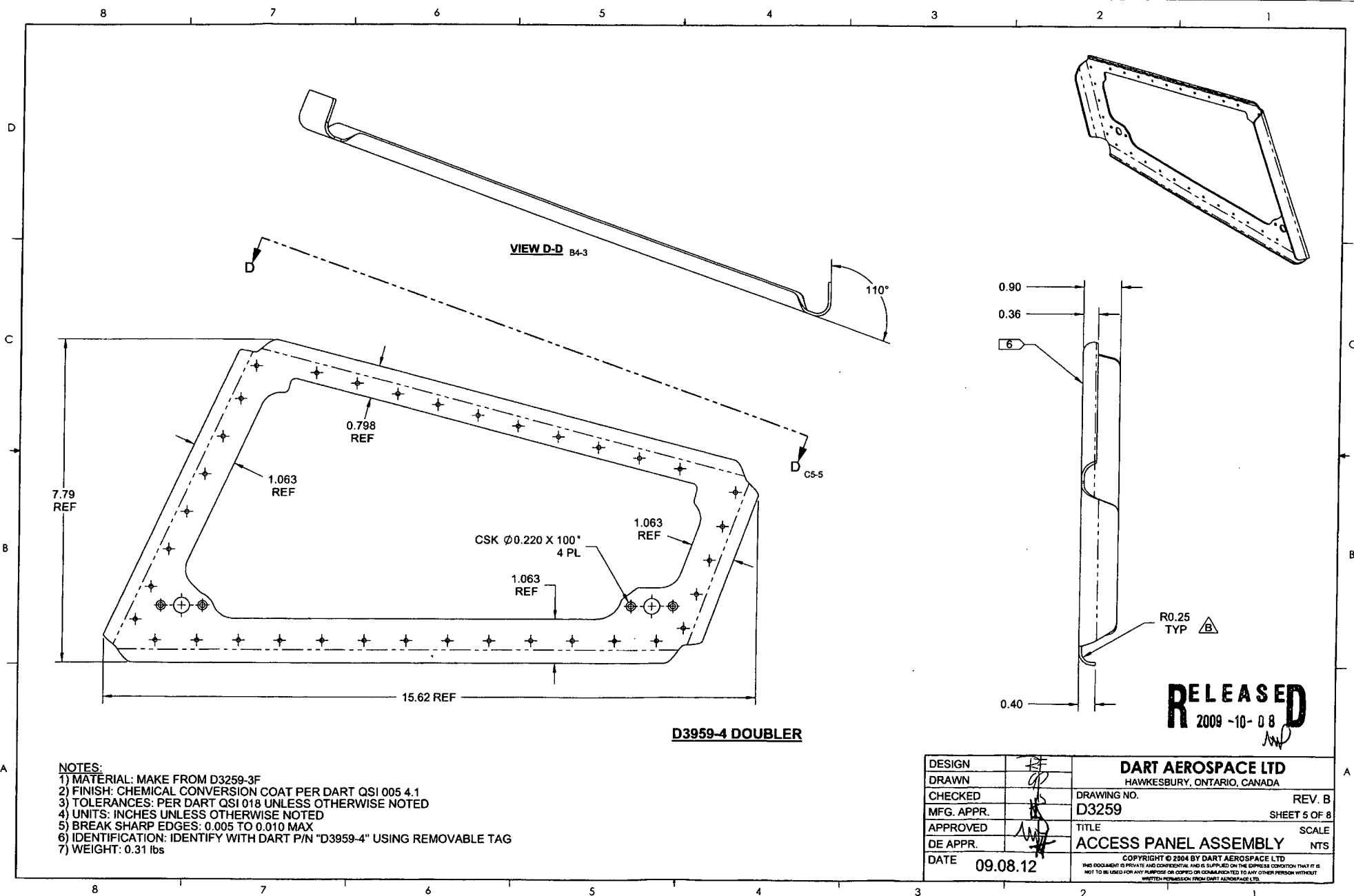
|            |                 |                                                                                                                                                                                                                                                                                          |              |
|------------|-----------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------|
| DESIGN     |                 | <b>DART AEROSPACE LTD</b>                                                                                                                                                                                                                                                                |              |
| DRAWN      |                 | HAWKESBURY, ONTARIO, CANADA                                                                                                                                                                                                                                                              |              |
| CHECKED    |                 | DRAWING NO. <b>D3259</b>                                                                                                                                                                                                                                                                 | REV. B       |
| MFG. APPR. |                 | TITLE                                                                                                                                                                                                                                                                                    | SHEET 3 OF 8 |
| APPROVED   |                 | <b>ACCESS PANEL ASSEMBLY</b>                                                                                                                                                                                                                                                             | SCALE        |
| DE APPR.   |                 |                                                                                                                                                                                                                                                                                          | NTS          |
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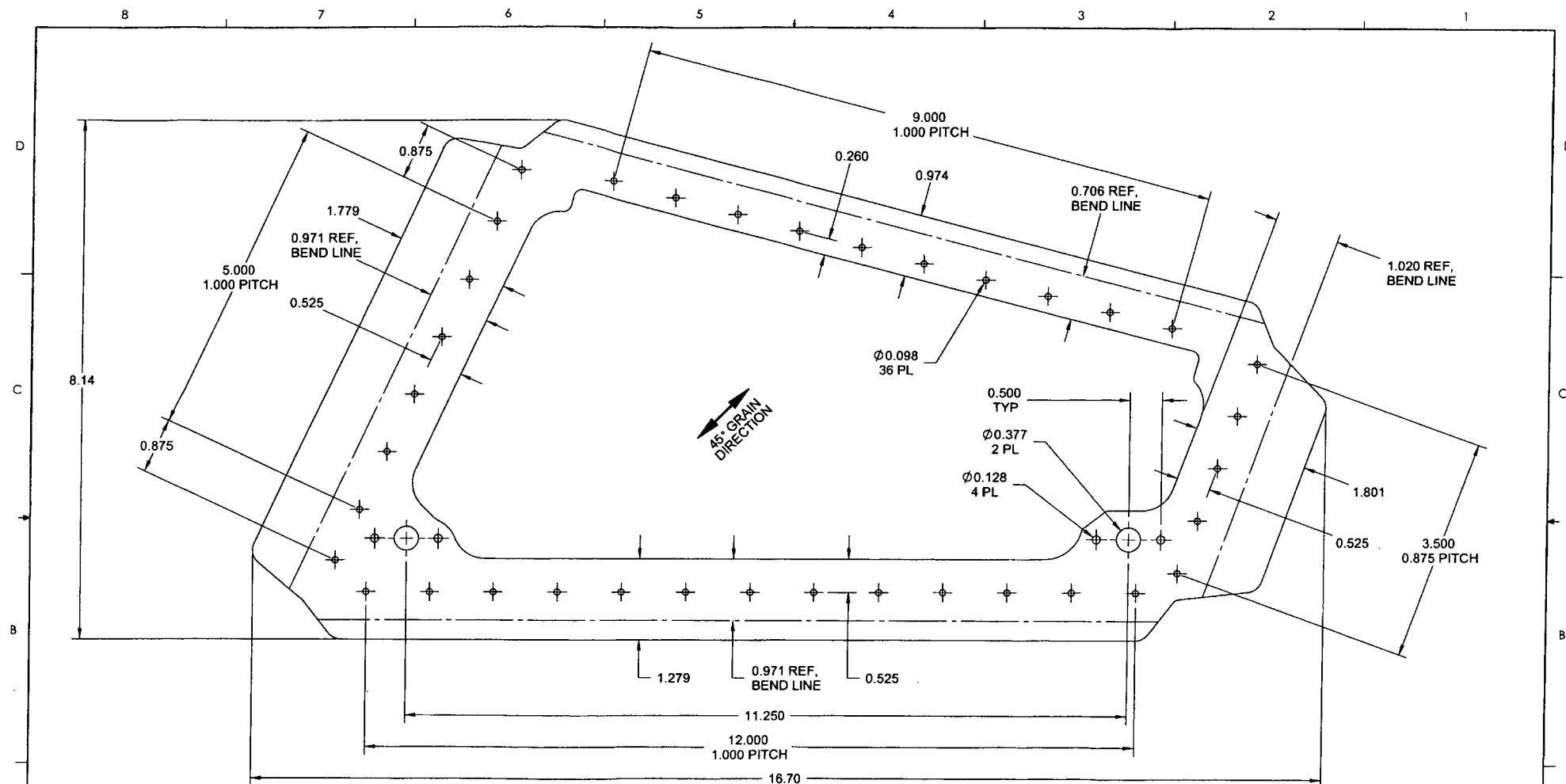




**NOTES:**

- 1) MATERIAL: MAKE FROM D3259-3F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3259-3" USING REMOVABLE TAG
- 7) WEIGHT: 0.31 lbs





### D3259-3F DOUBLER

#### NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.063 THICK PER AMS-QQ-A-250/4 OR AMS 4037 OR ASTM B209  
REF DART SPEC. M2024T3S.063
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3259-3F" USING REMOVABLE TAG
- 7) WEIGHT: 0.31 lbs
- 8) MAKE PER DWG FILE "D3259-3FB.DXF"

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| DRAWN      |          | HAWKESBURY, ONTARIO, CANADA                                                                                                                                                                                                                                                              |              |
| CHECKED    |          | DRAWING NO.                                                                                                                                                                                                                                                                              | REV. B       |
| MFG. APPR. |          | D3259                                                                                                                                                                                                                                                                                    | SHEET 6 OF 8 |
| APPROVED   |          | TITLE                                                                                                                                                                                                                                                                                    | SCALE        |
| DE APPR.   |          | ACCESS PANEL ASSEMBLY                                                                                                                                                                                                                                                                    | NTS          |
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